

WORK INSTRUCTION

Title: **Replacement of OCV Locking Z Flange**

Instruction No. **CH.07**

Rev. 0.1, March 2005

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Approved for Use by: Michael R. B. 3/7/2005 Effective Date: March 2005

Applicable Drawings:

- 2077-500SNP (Sheets 2, 3, 4 and 6) - TRUPACT-II Packaging SARP Drawings
- 707-SAR (Sheets 4 & 5) - HalfPACT Packaging SARP Drawings

SARP Requirements:

- There are no SARP requirements for this work instruction. The Z flange will be replaced as necessary.

Tools Required:

- Lift Equipment
- Lid Stand
- Flat Blade Screwdriver - 3/8-in. tip
- Calibrated Torque Wrench with flat tip screwdriver socket

Spare Parts Required:

- The spare parts are listed in the instruction steps. All spare parts listed are controlled and shall be recorded on the maintenance record.

Materials Required:

- Loctite #222 thread locking compound or equivalent
- Torque paint

Safety Requirements:

- Safety will be observed in accordance with site requirements.

Prerequisite Conditions:

- The OCA lid must be removed and set on the lid stand.

Instruction Steps:

- The spare parts listed below shall be replaced with like-for-like components from the approved spare parts supply.
- The replacement of these parts shall be documented on a **Maintenance Record**.
- This instruction **is not required to be attached** to the Maintenance Record but should be used as a checklist during performance of maintenance.

- ☐ OCV Locking Z Flange (PN 2077-161-01) PO# _____
- ☐ Z Flange Pan Head Screw (PN 2077-160-13) PO# _____
- ☐ Microlite Insulation (PN 2077-160-10) PO# _____

- 1.0 Loosen and remove the 36 pan head screws that fasten the locking Z flange to the lock ring.
- 2.0 Lower the locking Z Flange to the floor (2 or more people required).
- 3.0 Lift the OCA lid clear of the lid stand.
- 4.0 Remove old locking Z Flange, place new locking Z Flange over stand and place on floor.
- 5.0 Place OCA lid back on lid stand.
- 6.0 Install new ceramic fiber gasket per Work Instruction CH.02.
- 7.0 Inspect and replace microlite insulation if required.
- 8.0 Coat threads of screws with thread locking compound and attach new locking Z Flange to locking ring.
- 9.0 Torque screws 22 to 28 lb-in.
- 10.0 Apply continuous bead of torque paint from screw head to locking Z Flange.
- 11.0 Allow torque paint to cure in accordance with manufacturer's instructions.

Verification Requirements:

- 1.0 Spare parts used are listed on Maintenance Record.
- 2.0 Work performed described on Maintenance Record.
- 3.0 Work instruction listed on Maintenance Record.